

Work Order ID 121175

June-16-14 2:25:22 PM

\*121175\*

Page 1

Item ID: D4463-9

Revision ID:

Item Name: Tank Back

Start Date: 6/23/14

Required Date: 6/23/14

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Start Qty: 4.00

Req'd Qty: 4.00

\*4\*

\*4\*

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 140618

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4463

D

100

0.00

\*100\*

Waterjet

ALGW GNC Waterjet

Memo

Cut as per dwg

Prog rev: D

Dwg rev: D

0.00

(2)

mm

14/07/23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

(2)

mm

14/07/23

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

Memo

0.00

(2)

14/07/23

EP

14/07/23

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Item ID: D4463-9 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tank Back  
 Start Date: 6/23/14 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 6/23/14 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg  Memo	0.00  0.00		DAS 30 9-89		2			14/07/24
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00		DAS 27 9-89		2			14/07/24
150 *150* Hand Finish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				2			16/07/24

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Item ID: D4463-9 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tank Back  
 Start Date: 6/23/14 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 6/23/14 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				2	0		DAS 19 9-89 14.07.24
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>W11.003</u>  Memo	0.00  0.00				2	0		DAS 19 9-89 14.07.24
180 *180* QC Quality Control	QC21-Final Inspection - Work Order Release  Memo	0.00  0.00				MLJ			14.07.25 MLJ 14.07.25



# Picklist Print

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Work Order ID: 121175

**\*121175\***

Parent Item: D4463-9

**\*D4463-9\***

Parent Item Name: Tank Back

Start Date: 6/23/14

Required Date: 6/23/14

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC  
13.10.28 DWG REV PD1 DD VERF:JLM  
AS PER DWG REV.D DD VERF:JLM

IPP REV:B  
IPP REV:C 14.06.13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	380.7880	6.7	29			

**\*M6061T6S 063\***

6061-T6 .063 Sheet

**\*\***

mm 17/07/27

## Location

## Loc Qty

## Loc Code

MAT021

380.788

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

63.468

M128941

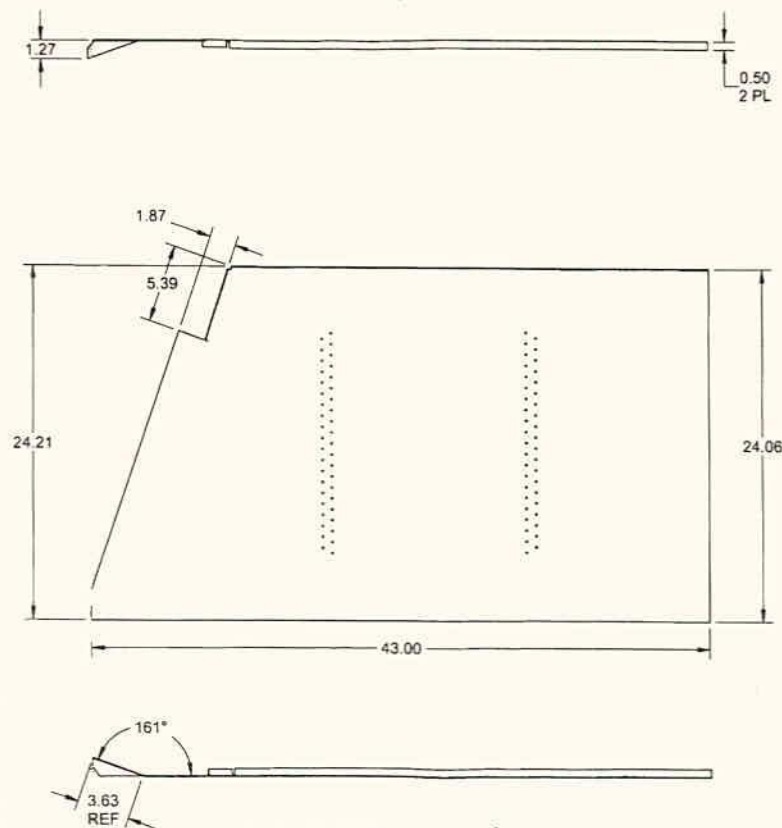
183

m.28545

15.



R0.19  
TYP



D4463-9 TANK BACK  $\Delta$

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

121175 MLS

1406-18

RELEASED  
2014-06-11

NOTES:

- 1) MATERIAL: MADE FROM D4463-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.68 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 9 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AUX TANK	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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